

Date: Thursday, 12/15/2005 3:55:20 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: GAS SPRING
Job Number	: 25247	Part Number	: D2807
Estimate Number	: 10336	Drawing Number	: D2807 REV C
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 12/15/2005 S.O. No. : N/A	Drawing Revision	: C
Prsht Rev.	: NC	Material	: N/A
First Issue	: N/A Type : PURCHASED PARTS	Due Date	: 12/22/2005
Previous Run	: 24622	Qty:	20 Um: Each
Written By	: SEE COMMENT BELOW		
Checked & Approved By	: SEE ABOVE USER & DATE		
Comment	: Est: D 05.06.21 Removed painting; Changed supplier KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0

PG

PURCHASING



Comment: PURCHASING

Issue P/O: 00000304

Order as per Dwg D2807

Possible supplier: ArvinMeritor Motion Control Systems

Material release note is required

2.0

D2807

Support Prop



Comment: Qty.: 0.0000 Each(s)/Unit Total: 0.0000 Each(s)

SUPPORT PROP

3.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect for Transit Damage

Ensure Material Release Note is attached

4.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Install lugs and crimp using DT8791 crimp jig.

2-Remove lettering and logo with wash and wipe.



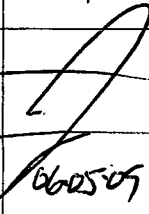
B 26625

SB 06/05/00

 PTO
 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 2 Date: 06/05/10
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/05/09	5	2 02807-3 tugs were installed from the batch that were no good (were drilled too deep) 2 shocks scrap.		give the 2 shocks to eng. and replace. <u>more shocks</u>	 06/05/09	 06/05/09		 06/05/09

wrong W/O

NOTE: Date & initial all entries

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Drawing Name: GAS SPRING

Job Number: 25247

Part Number: D2807

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

12/15/05 (20)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST*

parts used in GA.

12/15/05 (20)

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

12/15/05 (20)

Job Completion



12/15/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

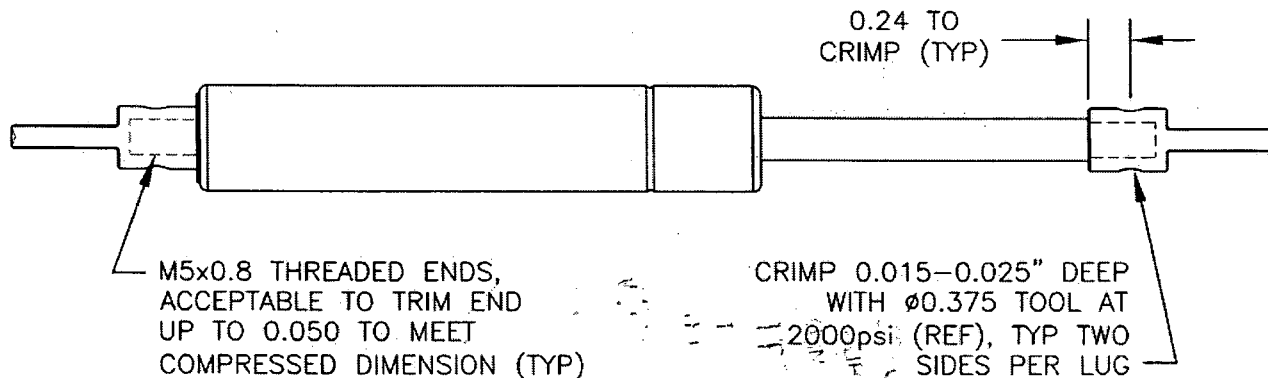
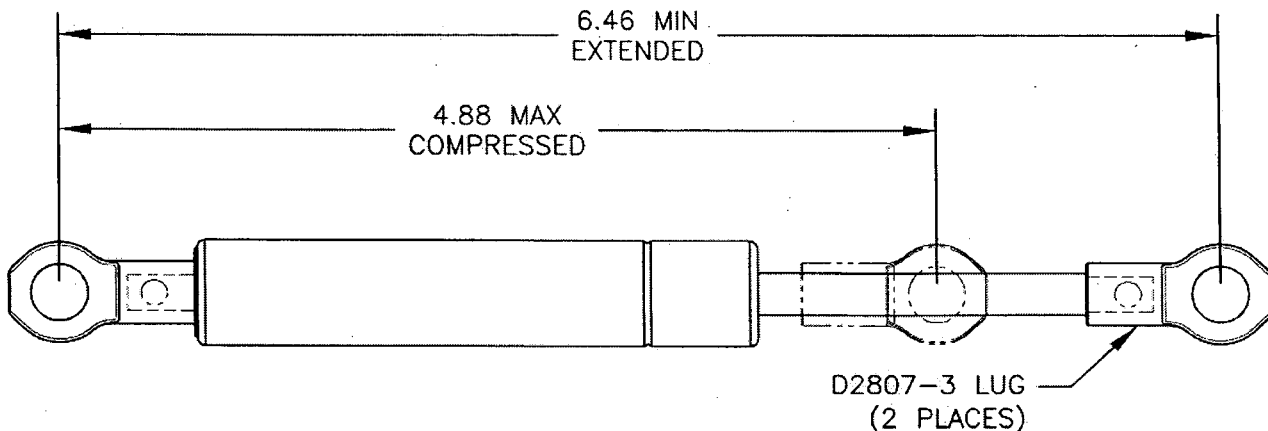
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

RELEASED
25-06-16



D2807 GAS SPRING

- 1) SPECIFICATION: SS GAS SPRING
ACCEPTABLE LOAD RANGE IS 25 lb MIN TO 45 lb MAX
M5x0.8 THREADS

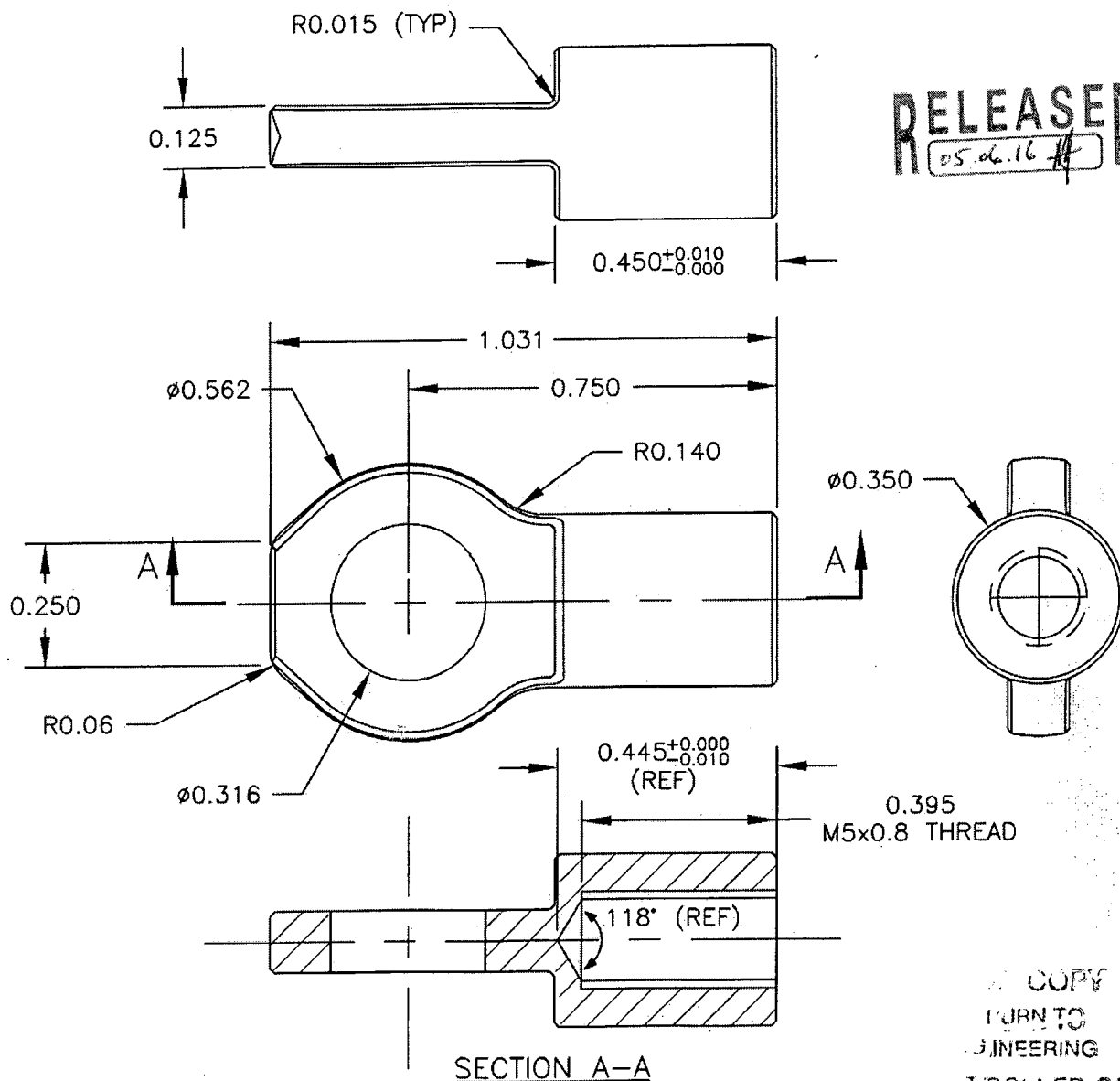
POSSIBLE SUPPLIER: ArvinMeritor Motion Control Systems, Leicester, UK
P/N: SXF6S6050080S6L-115N
(REF: 80mm LONG CYLINDER, 50mm STROKE, 115N LOAD)

- 3) ALL DIMENSIONS ARE IN INCHES
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CP	CP	DRAWING NO.	REV. C
CHECKED	APPROVED	D2807	SHEET 1 OF 2
DATE		TITLE	SCALE
05.05.25		GAS SPRING	1:1
A	00.11.03	NEW ISSUE	
B	05.03.16	ADD FINISH	
C	05.05.25	CHANGE SPRING TO SS, ADD -3 LUG	



DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2807	REV. C SHEET 2 OF 2
DATE 05.05.25	TITLE GAS SPRING		SCALE 3:1



D2807-3 LUG

- 1) MATERIAL: AISI 303 ROUND BAR (REF DART SPEC. M303R)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.015
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

COPY
TURN TO
ENGINEERING
TRIMMED COPY
FOR EXAMINATION
FIRST NOTICE

WORK ORDER
NO. 25247

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ArvinMeritor

Light Vehicle Aftermarket

DESPATCH NOTE/CERTIFICATE OF CONFORMITY

55927/001

INVOICE TO:

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ONTARIO
K6A 1K7
CANADA

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ONTARIO
K6A 1K7
CANADA

PICKING LIST No.

OUR REF.

55927

DATE

180106

A/C No.

20111

AREA

44

CUSTOMER REF No.

FD 00000304

V.A.T. REGISTRATION No: GB 738 8577 71

W. ORDER

NUMBER
QTY ALLOC
XXXXXXXXXX

165146

QTY. SHIPPED

BATCH No.

20

QTY. ORDERED

20

EA

PART NUMBER

SXF6050500047

DESCRIPTION

SXF6 S6 050 0 80 S6 L 20mm
32AWS 115N NNN SP1

DUE DATE

17JAN06

SPECIAL INSTRUCTIONS

SHIP DATE

CARRIER CODE

WEIGHT

DESPATCH TICKET

18JAN06